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RBW1205G00332-3G**Job Sheet 189484****Part No:** RBW1205G00332-3G**Job Qty:** 1 pcs**Part Name:** Main Gear Box Oil Draining Hose**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/25/19**Job Tracking No:****Due Date:** 1/28/19**Created By:** Linda Lacelle**Type:** SOLD**Description:****Note:** DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	1/28/19		0.00	1.33	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	1/28/19		0.00	0.00	QC 5 - 10		DAS 30 989
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	1/28/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	1/28/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op **100** - Small Fab - 1-Cut 9657k135 (-25) spring to 0.5" as per work order deviation 2-Assemble as per DWG sheet 1.
 Descriptions: Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).
110 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

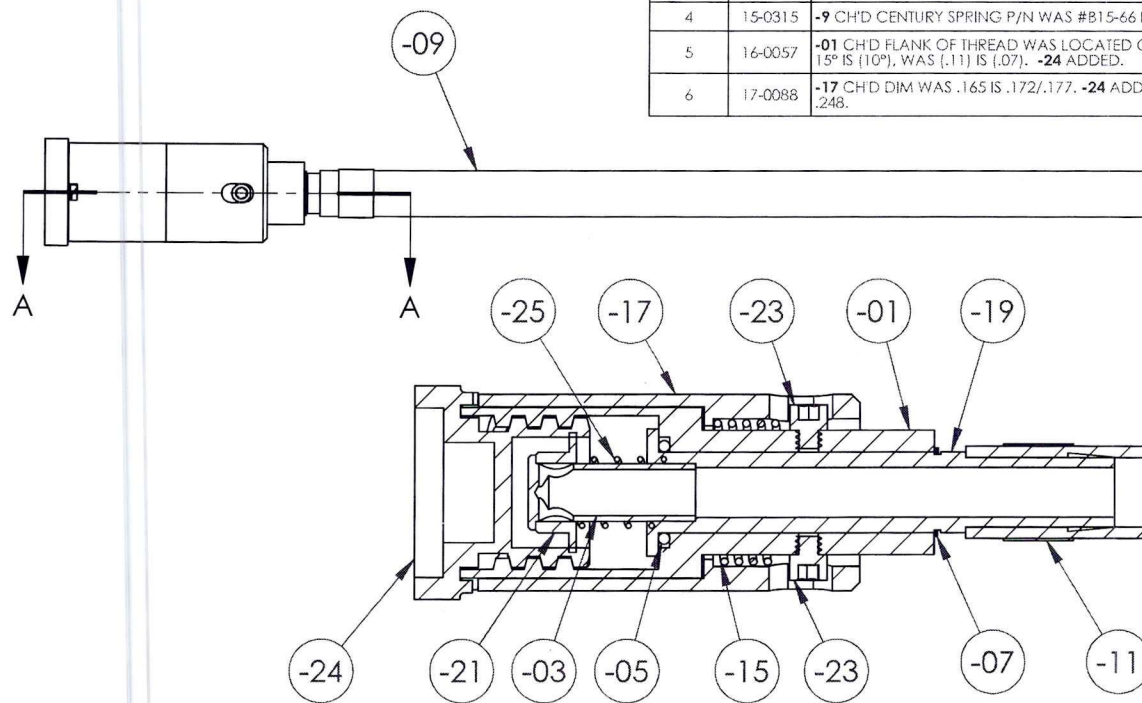
Part / Item	Component Name	Quantity	Operation	Container
1315	Crimp Hose Clamp 9/16"	1 pcs (1 ea)	100-Small Fab - 1	5042369
2619	Spring Rnd 3/4"	1 Ea (1 ea)	100-Small Fab - 1	5075095
4464T123	O-Ring 9/16 Od X 1/16 Cross	1 Ea (1 ea)	100-Small Fab - 1	5048577
91665A350	Retaining Ring, 7/16" Shaft	1 Ea (1 ea)	100-Small Fab - 1	5046064
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	6 ft (6 ea)	100-Small Fab - 1	5093411
RBW1205G00332-3G-01	Cap	1 pcs (1 ea)	100-Small Fab - 1	5137030
RBW1205G00332-3G-03	Quill	1 pcs (1 ea)	100-Small Fab - 1	5139009
RBW1205G00332-3G-17	Sleeve	1 pcs (1 ea)	100-Small Fab - 1	5136982
RBW1205G00332-3G-19	Barb	1 pcs (1 ea)	100-Small Fab - 1	510398
RBW1205G00332-3G-21	Valve	1 pcs (1 ea)	100-Small Fab - 1	5137144
RBW1205G00332-3G-23	Screw (Modified B/O)	2 pcs (2 ea)	100-Small Fab - 1	5117421
RBW1205G00332-3G-24	End Cap	1 pcs (1 ea)	100-Small Fab - 1	5137017
9657K135	Spring	1 Ea (1 ea)	100-Small Fab - 1	5097612
M304TR0.375W.065	304 Round Tube .375 X .065W	.0830 ft (.083 ea)	100-Small Fab - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	1315	1	51	0
	2619	1	38	0
	4464T123	1	40	0
	91665A350	1	17	0
	9657K135	1	11	0
	K010-0608	6	361	0
	M304TR0.375W.065	0	60	0
	RBW1205G00332-3G-01	1	12	0
	RBW1205G00332-3G-03	1	16	0
	RBW1205G00332-3G-17	1	8	0
	RBW1205G00332-3G-19	1	14	0
	RBW1205G00332-3G-21	1	13	0
	RBW1205G00332-3G-23	2	1	0
	RBW1205G00332-3G-24	1	12	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED WITH SHUTOFF AND RETAINING SLEEVE, ADDED PARTS -03, -17, -19, -21 & -23.	3/2/2011	JAG	
2		-01 CH'D TO CLEAR ANODIZE, THREAD CORRECTED TO 13/16-6. -03 CH'D HOLE FROM Ø.20, CH'D LIMIT DIM FROM Ø.3135 - .3139. -17 CH'D TO CLEAR ANODIZE. -19 CH'D HOLE DIA. FROM Ø.26 AND .10 FLANGE TO .06. -21 CH'D Ø.313 TO LIMIT DIM S.F.	11/30/2011	RJC	DW
3		-17 ADDED ENGRAVE NOTE. -23 CH'D O.D. FROM Ø.20 TO Ø.200 +.003 -.000.	2/15/2012	RJC	SE
3A		-13 DELETE, ENGRAVING IS ON -17.	5/2/2013	RJC	RJC
4	15-0315	-9 CH'D CENTURY SPRING P/N WAS #B15-66 IS #2619.	9/30/2015	RJC	JAG
5	16-0057	-01 CH'D FLANK OF THREAD WAS LOCATED ON CENTERLINE IS OFFSET 13° FROM CENTERLINE; WAS 15° IS (.10°), WAS (.11) IS (.07). -24 ADDED.	6/16/2016	SM	JAG
6	17-0088	-17 CH'D DIM WAS .165 IS .172/.177. -24 ADDED DIMS .696, Ø1.09, MIN. R. DELETED DIMS 2X .068, .248.	4/17/2017	RJC	JAG



SECTION A-A
SCALE 1 : 1

NOTE:
FUNCTION: PART OF HELICOPTER SERVICING KIT PART No 3G1205G00131. USED TO DRAIN OIL FROM THE MGB THROUGH THE PARKER STRATOFLEX COUPLING, RBW1205G00332-3G REPLACES STRATOFLEX (11362) (A3Q07) P/N 165006.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	✓		-01	1	CAP	6061		2
	✓		-03	1	QUILL	303/304 S.S.		3
	✓	B/O	-05	1	O-RING	BURNA-N	9/16 OD X 1/16 CROSS (MCMaster-CARR #4464T123)	1
	✓	B/O	-07	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT MCMaster-CARR #91665A350	1
	✓	B/O	-09	1	HOSE	VINYL	Ø1/2 X 3/8 X 6 FT. KURI-TECH #K010-0608	1
	✓	B/O	-11	1	CRIMP HOSE CLAMP	S.S.	Ø1/2 DIXON VALVE #OET-1315	1
	✓	B/O	-15	1	SPRING	SPRING STEEL	Ø3/4 CENTURY SPRING #2619	1
	✓		-17	1	SLEEVE	6061		4
	✓		-19	1	BARB	303/304 S.S.		5
	✓		-21	1	VALVE	303/304 S.S.		6
	✓		-23	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	7
	✓		-24	1	END CAP	6061		8
	✓	B/O	-25	1	SPRING	MUSIC WIRE	Ø.028 WIRE: Ø.360 OD X .5 FREE LENG RIED #S1165	1



TITLE		MAIN GEAR BOX DRAIN TOOL	
DWG NO.		RBW1205G00332-3G	
REV		6	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		PERRITT	
CHECKED:		DUERFELDT	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:2	
DATE		2/23/2011	
SHEET		1 OF 8	

1 insto-15 8 not started machinist